

Work Order ID 140805

140805

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January 19, 2016 10:32:06 AM

Item ID: D2161-212 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mirror Bracket, 212
 Start Date: 3/28/19/2016 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 2/2/2016 Req'd Qty: 5.00 *5* Customer:
 Reference: 47

Approvals: Process Plan: SH Date: 20160119 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2161	Rev B2								
100	Weld per dwg A/R S.S. rod Batch: 123823	0.00				5		16-03-28	
100	Large Fab								
	Memo	0.07							
	1-Assemble on Jig DT8065 as per Dwg D2161								
	2-Weld as per Dwg D2161 Identify as D2161-212								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 140805

140805

January 19, 2016 10:32:06 AM

Item ID: D2161-212

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mirror Bracket, 212

Start Date: 1/19/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 2/2/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 129777.</i> Memo START TIME: <u>8:00</u> , OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>8:30</u>	0.00 0.00				<u>5</u>	<u>16-03-29</u>	<u>233</u>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>5</u>			DAS 38 9-89 MAR 29 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>St 226</u> Memo	0.00 0.00				<u>5</u>			DAS 6 9-89 MAR 30 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 140805***140805***

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January 19, 2016 10:32:06 AM

Item ID: D2161-212 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mirror Bracket, 212
Start Date: 1/19/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 2/2/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.01							
Quality Control									

APR 01 2016
MF
16-3-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause				FAULT CATEGORY			
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Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

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Work Order ID: 140805

140805

Parent Item: D2161-212

D2161-212

Parent Item Name: Mirror Bracket, 212

Start Date: 1/19/2016

Required Date: 2/2/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP D02.04.15 Added dwg Rev.B1 and finishNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2013-3		Manufactured	No			100	Each	7.0000	1	5			

D2013-3

Mirror Bracket LH, 212

16-03-24

JBC

Location

Loc Qty

Loc Code

WA001

7

117821

4

120883

3

2
3

* Qty Shown 2?

D2013-4

Manufactured

No

100

Each

7.0000

1

5

D2013-4

Mirror Bracket RH, 212

16-03-24

JBC

Location

Loc Qty

Loc Code

WA001

7

117831

4

120884

3

4
11

D2037-101

Manufactured

No

100

Each

10.0000

1

5

D2037-101

Arm

16-03-24

JBC

Location

Loc Qty

Loc Code

WA001

10

117856

6

123425

4

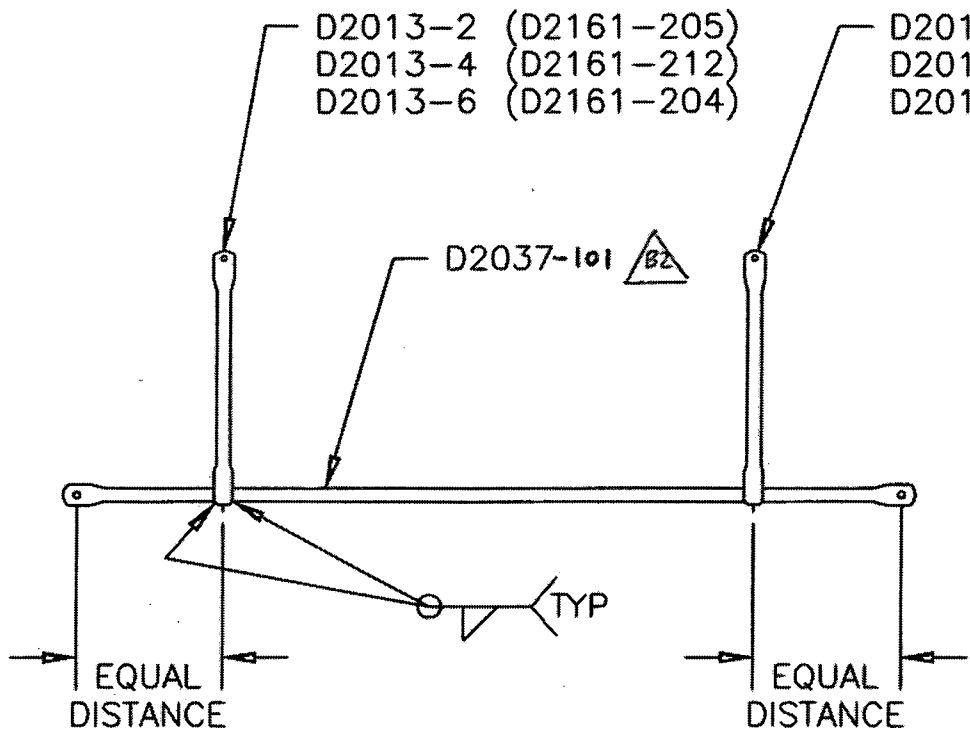
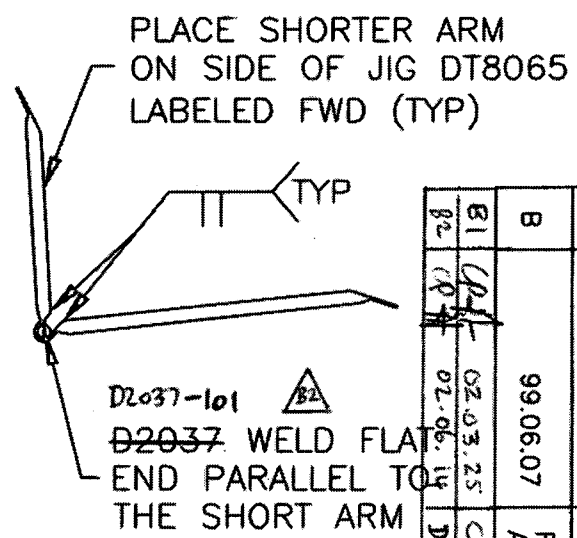
2
3



DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	RT	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
4E	4E	D2161
DATE	TITLE	SHEET 1 OF 1
99.06.07	MIRROR BRACKET	SCALE
		NIS

A	93.04.29	NEW ISSUE
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS
B1	02.03.25	CHANGE FINISH
B2	02.06.14	D2037-101 WELD FLAT

RELEASED
4E 99.06.10



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK-~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3

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